

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005716**Date Inspected:** 09-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (South of the paint shop)

This QA Inspector observed the following work in progress:

Segment 5AW

Shielded Metal Arc Welding (SMAW) in the 4G position of the side plate to corner assembly splice welds previously rejected by ZPMC QC personnel. The welder is identified as #067056. The weld designation is SEG21A-001. ZPMC QC is identified as Mr. Zhang Bao Lai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-Repair.

Shielded Metal Arc Welding (SMAW) in the 4G position of the side plate to corner assembly splice welds previously rejected by ZPMC QC personnel. The welder is identified as #037723. The weld designation is SEG21A-010. ZPMC QC is identified as Mr. Zhang Bao Lai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-Repair.

Shielded Metal Arc Welding (SMAW) in the 3G position of the transverse angle stiffener attachment weld to the side plate T-ribs. The welder is identified as #045143. ZPMC QC is identified as Mr. Zhang Bao Lai. The welding variables recorded by QC appeared to comply with the applicable WPS.

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Segment 5CE

This QA Inspector observed that there was no work being done on this segment.

Segment 5CW

This QA Inspector observed that there was no work being done on this segment.

Segment 5BW

This QA Inspector observed that there was no work being done on this segment.

BAY 14

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the deck panel U-rib extension splice welds. The Weld Designations are as follows: DP575-001-045, DP575-001-056, DP575-001-067 and DP575-001-078.

BAY 19

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the cross beam bottom panel splice welds. The Weld Designations are as follows: BP027-001-001, BP027-001-002, BP027-001-003 and BP028-001-001.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the bike path splice welds. The Weld Designations are as follows: BK006A1-001-009 and BK006A1-002-009.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the floor beam component welds for crossbeam 3. The Weld Designations are as follows: FB209-002-028, FB209-002-005, and FB209-001-012.

BAY 7

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the deck panel splice welds. The Weld Designations are as follows: DP702-001-036, DP689-001-035, DP715-001-023 and DP676-001-025.

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the side panel T-rib stiffener splice welds. The Weld Designations are as follows: SP354-001-037, SP354-001-039, SP354-001-040, SP354-001-047, SP168-001-045, SP168-001-051, SP168-001-053, SP381-001-043, SP381-001-045, SP381-001-049, SP141-001-043, SP141-001-045, SP141-001-051, SP114-001-050, SP114-001-052, SP114-001-054, SP327-001-043, SP327-001-044, SP327-001-060 and SP327-001-062.

BAY 1

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This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as the OBG crossbeam welds. The Weld Designations are as follows: CB203F-001-001, CB203F-001-002, CB203F-001-005, CB203F-001-006, CB203F-001-009 and CB203F-001-010.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

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| Inspected By: | Patterson,Rodney | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
